

Date: Tuesday, 26/09/2006 8:24:07 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG BRACKET
Job Number : 28720	
Estimate Number : 10364	
P.O. Number :	Part Number : D3046041
This Issue : 26/09/2006 S.O. No. :	Drawing Number : D3046 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : 26/09/2006 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 28598	Material :
Written By :	Due Date : 03/10/2006
Checked & Approved By :	Qty: 10 ⁹ Um: Each
Comment : Est: A 01.08.27 New issue SM/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D30461	Lug Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

LUG BRACKET

Qty	Part Number	Description	Batch
1	D3046-1	Lug Bracket	B28599

2.0	D30463	Lug Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

LUG BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D3046-3 (Bell P/N: 206-052-106-1)	Lug Bracket	B28719
Return Authorization #			N/A
Bell original batch#			RTN 521
			28237/167715/117607/37513/4071

3.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

POWDER COAT WHITE D3046-3

Y.L
G.M 06-09-26

4.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 09 26 (9)

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Drawing Name: LUG BRACKET

Job Number: 28720

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Transfer drill holes from D3046-3 into D3046-1 as per Dwg D3046
- 2- Counter sink inside holes of D3046-1 as per Dwg D3046
- 3- Deburr

9
10
SF 06-09-27

6.0

MS20426AD57

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total: 80.0000 Each(s)

Rivet

Qty Part Number

Description

Batch

M 3874

(58)

10

MS20426AD5-7

Rivet

M 7681

(32)

9
SB 06/09/27

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3046

9
SB 06/09/27

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9
J 06-09-27

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

Q.M 06-09-28

(9)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9
FC 06 09 28

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A

9
FC 06 09 28

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 28720

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



②

Comment: FINAL INSPECTION/W/O RELEASE

206/09/28

Job Completion



U 06-09-28

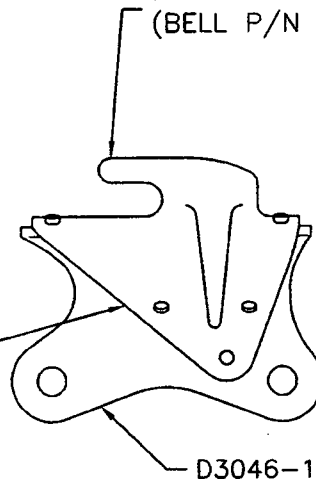
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
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CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3046
DATE	TITLE	REV. A
01.08.23	LUG BRACKET	SHEET 1 OF 2
A	01.08.23	NEW ISSUE
		SCALE 1:2

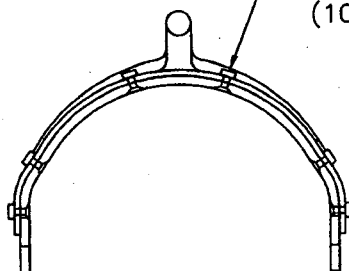
REFERENCE ONLY

D3046-3
(BELL P/N 206-052-106-1)



D3046-1

CENTER D3046-3
ON D3046-1



TRANSFER DRILL Ø0.156 HOLES
FROM D3046-3 TO D3046-1.
C'SINK Ø0.286 x 100°
D3046-1 INSIDE BORE.
ASSEMBLE USING MS20426AD5-7
RIVETS.
(10 PLACES)

D3046-041 LUG BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.
RE-POWDER AFTER ASSEMBLY.
- 2) REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

UNDER REVIEW

06.06.02 *[Signature]*

Engineering to be reviewed
DESIGN

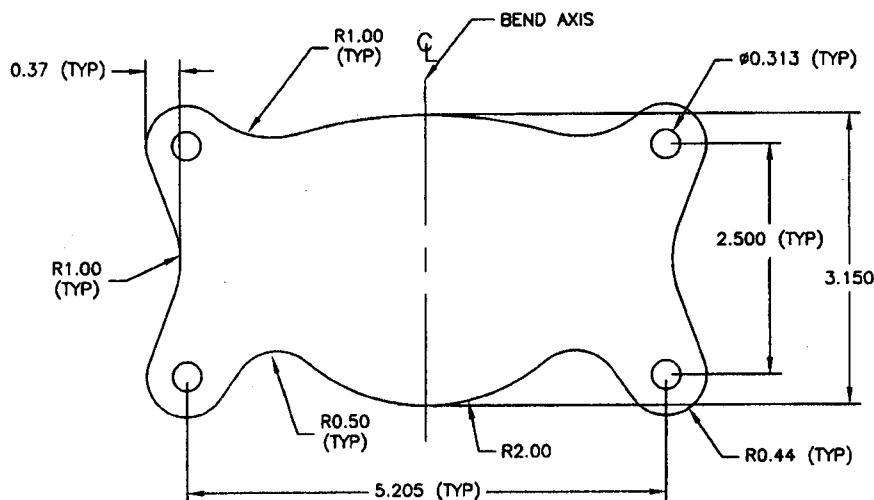
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01.08.23

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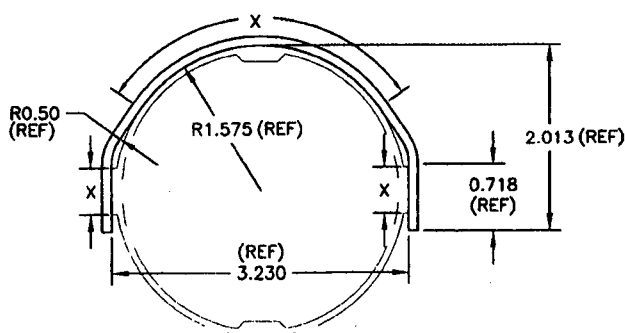
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DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RT	APPROVED RT	DRAWING NO. D3046	REV. A SHEET 2 OF 2
DATE 01.08.23		TITLE LUG BRACKET	SCALE 1:2



D3046-11 FLAT PATTERN
SYMMETRICAL ABOUT CENTRE-LINES (Q)



D3046-1
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

RELEASED
01.08.27

UNDER REVIEW

06.06.23

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